



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3022-1
Job Sheet 181211



Part No: D3022-1

Job Qty: 2 ea

Part Name: Seat Pan



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/24/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP C 02.01.23 Revised NG IPP Rev:D 08-04-16 now water jet DD verified by:EC IPP Rev:E 08-12-18 as per ECN08-582 DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	8/31/18	8/31/18	0.00	0.00	Start Up Waterjet		SC 8/10/18
100	Waterjet	2 pcs	8/31/18	8/31/18	0.00	0.57	Waterjet1		SC 8/10/18
110	QC	2 pcs	8/31/18	8/31/18	0.00	0.00	QC2 Waterjet-1		SC 8/10/18
120	QC	2 pcs	8/31/18	8/31/18	0.00	0.00	QC8-1		38
130	Brake NC	2 pcs	8/31/18	8/31/18	0.00	0.33	Brake NC 2		9-89 DAS
140	QC	2 pcs	8/31/18	8/31/18	0.00	0.00	QC5		SEP 10 2018 68
200	Packaging	2 pcs	8/31/18	8/31/18	0.00	0.00	Packaging3		12 9-89
210	QC21-SA	2 Ea	8/31/18	8/31/18	0.00	0.00	QC21		DAS 21 9-89

Part Op 100 - 1-Cut as per Dwg D3022

Descriptions: 200 - LOCATION: WA001

210 - *** HOLES WILL BE OPEN AND TRANSFER DRILLED AT ASSEMBLY***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.032	2024-T3 .032 Sheet	6.5540 sf (3.277 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.032	7	58	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Seat Pan	14.750Inches ± 0.030	14.780 14.720	14,752	
2	Seat Pan	12.280Inches ± 0.030	12.310 12.250	12,283	
3	Seat Pan	2.720Inches ± 0.030	2.750 2.690	2,719	
4	Seat Pan	14.620Inches ± 0.030	14.650 14.590	14,622	
5	Seat Pan	12.150Inches ± 0.030	12.180	12,148	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐			

Date : _____ Step #: _____

MRB (QSI042) Approval

Description Work Order Deviation

--

Part: D3022-1
 Job No: 181211
 Serial No/Batch: S104772
 Revision:
 Inspector:
 Exp Date:
 Instructions: Various STC's

Date: 08/24/18



ated By

/ Supervisor
VerificationCoordinator
Approval

DART Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL.: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Root Cause									
Environment ☐	No Re-verification ☐	Pressure/Force ☐							Used Wrong ☐
Design ☐	Operator ☐	Bending ☐							Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not ☐							Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐							correct ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	Wrong Stock Picked ☐				Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐		Contamination ☐	Out of Sequence ☐				Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐		Countersink ☐	Off-set ☐				Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐		Cut Too Short ☐	Mislabeled ☐				Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	Fit/Function ☐				Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐		Drill Holes ☐	Misaligned/off center ☐				Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					